

ASAP

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:08:41 PM
 User: Julie Lemoine

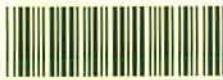
Process Sheet

SPLIT-1

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	STEP WELDMENT		
Job Number	41038			Part Number	D3562041		
Estimate Number	12576			Drawing Number	D3562 REV E		
P.O. Number				Project Number	N/A		
This Issue	06/08/2008	S.O. No.	:	Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	29/08/2008	Qty:	<u>2</u>
Previous Run	40288			Um:	Each		
Written By							
Checked & Approved By	<u>JUL 08.8.06</u>						
Comment	Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD Est Rev:C ECN1048 07-12-18 DD verified by:ec Est Rev:D 08-07-28 add chemical conversion coat DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2622120C	Step Extrusion	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Qty Part # Description Batch: 1 D2622-120C Extrusion <u>40937</u>			
Check Material for any Dents or Defects <i>Dad 08/08/2008</i>			
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
Comment: LARGE FABRICATION RESOURCE 1 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding <i>Dad 08/08/2008</i>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP <i>Schaefer 29/08/2008</i>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>HJ 08-09-03 (25)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/08/2008 2:08:41 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopter's Services

Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



S 08/08/08 (2x)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT B 40299

Batch: B 40299



SP 08.09.08

(2x)

7.0 D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

ARM WELDMENT

Batch: B 40300

SP 08.09.08.

(2x)

8.0 MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total : 160.0000 Each(s)

Blind Rivet

batch: B M 108990

SP 08.09.08.

(2x)

9.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

SP 08.09.08 (2x)

2-Touch-up rivet holes with alodine as per dwg d3562

SP 08.09.08 (2x)

3-Rivet legs using Magnabond as per dwg D3562.

SP 08.09.08 (2x)

*****Ensure to wipe off any excess magnabond *****

A/R Magnabond 6398 Batch: M 106095

10.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/08 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 D2734 Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B39179

SP 08.09.09 BX

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M108037

SAD 08/09/10 BX

2-Grind end cap welds flush as per Dwg D3562

SP 08.09.09 BX

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PI 08-09-10 (2)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S ootarka (7)

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



(2X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. A 08/09/10

16.0 POWDER COATING POWDER COATING



M108623

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30AM

OVEN TEMPERATURE: 370°F

FINISH TIME: 9:00AM

9A

08-09-11 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: STEP WELDMENT

Job Number: 41038

Part Number: D3562041

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



m 108492

Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

FL 08/09/11 (2)

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

G-A E 08/09/11 (2)

20.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/12 (2)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



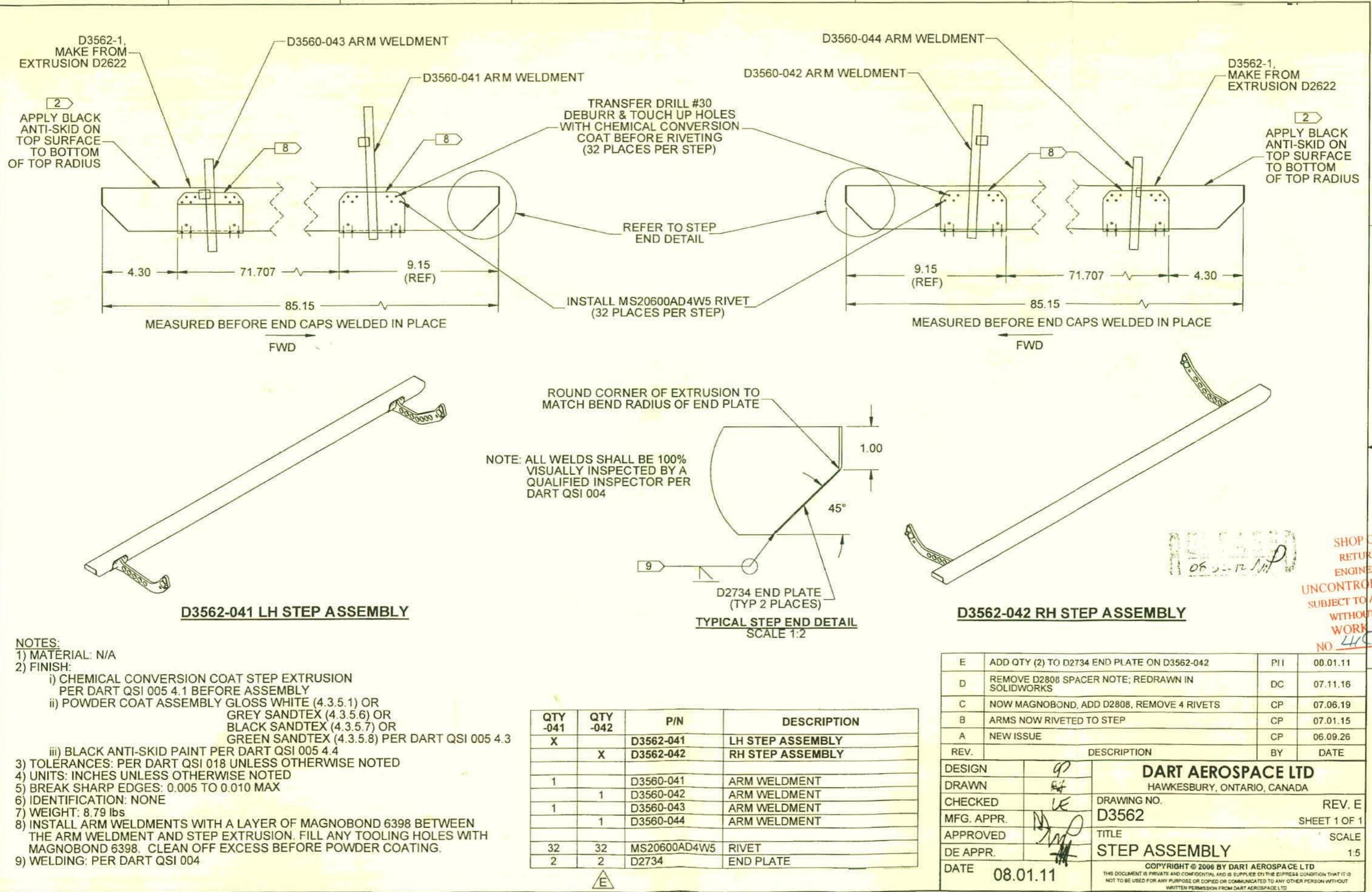
MF 08-09-11

W/O:		WORK ORDER CHANGES					
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E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PII	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	DART AEROSPACE LTD	
DRAWN	84	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	D3562
MFG. APPR.	N	REV. E	SHEET 1 OF 1
APPROVED	M	TITLE	STEP ASSEMBLY
DE APPR.	N	SCALE	1:5
DATE	08.01.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

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